

**Work Order ID: 66755**

Page 1

Friday, February 25, 2011 1:09:32 PM

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

4-0225

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

n1 11 04 14 17

B66755

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr.4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade  
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)7- Cleecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting  
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up  
holes for ground handling and detail C to 0.500" (8 holes per side)9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 11/03/18

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: ☐

M116577 BE 11/03/08

12-Grind welds flush as per Dwg D2750

BE 11/03/08

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 11/03/08

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/03/08

(6)

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

BB 11/03/22

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-3-22

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: M116040 ☐☐☐  
exp. date: 09/2011

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M116577

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BE11/03/25

BE11/03/31  
BE11/03/31

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

BE11/03/31

12-Deburr holes

BE11/03/31

170

QC10- Inspect visual per QS1004- ground welds

0.00



QC

Memo

0.00

8/11/03/31

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/11/03/31

Quality Control

X

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Hand Finishing

Re-align tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0 11/04/01

200



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30 320° 10:00

1 0 11-4-1

210



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 0 11/04/05

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	✓ 1- Install inserts as per Dwg D2750								
230		0.00							
	HandFinishing								
HandFinish	✓ Memo	0.00							
Hand Finishing	✓ 1-Inspect for Foreign Objects								
	✓ 2-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>2/11/16040</u> EXP DATE: <u>11/09</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube ✓ A/R 55-o'ring lube batch: <u>1/11/14189</u>								
	✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>1/11/14596</u>								

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

8 x 10 x 105



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/14

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

11 04 14 17

W/O:		WORK ORDER CHANGES					
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Stop

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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

Memo

Package as per PPP D350-636-011

0.00

Packaging

0.00

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

Rev I

Loch

11/4/14

12

11/4/15

MF  
11-04-14

W/O:		WORK ORDER CHANGES					
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**Parent Item Name:** Skidtube LH

**Required Date:** 3/11/2011

**Required Qty: 1.00**

**Comments:**

IPP Rev:I	02.09.25	Rearranged procedure steps	KJ	
IPP Rev:J	06-03-23	As per Rev D	JLM	
IPP Rev:K	06-07-13	As per dsi9343	EC	
IPP Rev:L	07-07-28	Added SS Wearplates(Rev E)	JLM	Verified By:EC
IPP Rev:M	08-04-22	update steps 4, 13	DD	verified by:EC
IPP Rev:N	08-09-23	revF as per dwg	DD	verified by:ec
IPP Rev:O	09-02-06	apply antiseize on AN8C21A bolts as per PAR09-010		
DD	verified by:EC			IPP Rev:P 10.06.22
revise seq110	DD	verf:EC		IPP Rev:Q 10.10.01 as per IIN
revH	DD	verf:EC		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 		Manufactured	No			230	Each	1,031.000	8	8		11/04/05	
O-Ring, 205 Skidtube													
				<u>Location</u>									
				FP				543					
					55546			19					
					58191			12					
					59358			12					
					<u>65518</u>			500					
				fpa				488			X8		
					61762			488					
AN960JD816 		Purchased	No			250	Each	89.0000	2	2		11/4/10	
1/2" washer, Alum													
				<u>Location</u>									
				ST348				89					
					106043			89					

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# Picklist Print

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Work Order ID: 66755

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2744



Cap

Manufactured No

110 Each

55.0000

1

1



BE 11/03/18

Location

Loc Qty

Loc Code

LG

29

65086

29

ST

26

62715

26

D2600-3-BENT



Extrusion Bent

Manufactured No

110 Each

6.0000

1

1



Location

Loc Qty

Loc Code

LG

6

61634

2

62764

1

64434

3

D2743



Crossbolt Spacer

Manufactured No

160 Each

122.0000

8

8



BE 11/03/18

Location

Loc Qty

Loc Code

LG

122

50281

10

57953

2

59111

10

61844

16

64003

84

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 25, 2011 1:09:39 PM

Work Order ID: 66755

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No

160 Each

4.0000

1 1



350 I Beam



BE 11/03/25  
B 66981 x 1

Location

Loc Qty

Loc Code

LG

4

64448

4

D3490-3 Manufactured No

160 Each

35.0000

4 4



Cross Bolt Spacer



BE 11/03/31

Location

Loc Qty

Loc Code

LG

35

60294

1

63556

24

64006

10

D3490-1 Manufactured No

160 Each

61.0000

4 4



Cross Bolt Spacer



BE 11/03/31

Location

Loc Qty

Loc Code

LG

61

59424

3

62450

48

64005

10

ALS4-1032-225 Purchased No

220 Each

3,945.000

38 38



Insert



11/04/05

Location

Loc Qty

Loc Code

PK011

3945

110768

3945

y38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:39 PM

Work Order ID: 66755

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230

Each

93.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP013

93

59114

1

62210

3

63994

29

65068

60



xl 11/04/05

D3793-3

Manufactured No

230

Each

20.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

15

39479

1

39812

2

64447

12

FP18

4

61711

4

FP19

1

57947

1



xl 11/04/05

AN8C35A

Purchased No

230

Each

61.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST345

25

116874

25

ST346

36

114442

5

115188

5

115960

26



xl 11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:40 PM

Work Order ID: 66755



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230 Each

25.0000

1

1



Wearshoe



*HL 11/04/05*

Location

Loc Qty

Loc Code

FP018

17

39277

1

39715

2

64445

14

FP18

8

59151

1

59630

1

61710

6

*XL*

D3488-041

Manufactured No

230 Each

17.0000

1

1



Blade Fitting Assembly, LH



*HL 11/04/05*

Location

Loc Qty

Loc Code

FG008

10

62002

10

FP18

7

61689

7

*XL*

D3794-3

Manufactured No

230 Each

19.0000

1

1



Gasket



*HL 11/04/05*

Location

Loc Qty

Loc Code

FP010

3

39422

3

FP10

15

60826

1

61712

14

*XL*

FP18

1

59153

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:40 PM

Work Order ID: 66755

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00


Required Qty: 1.00

AN6C44A Purchased No 230 Each 97.0000 4 4  
  
 BOLT

Location Loc Qty Loc Code

FG 2  
 103964 2  
 ST344 95  
 111649 2  
 114653 1  
 115936 42  
 116874 50


*Handwritten:* 11/04/05

MS21083C8 Purchased No 230 Each 43.0000 1 1  
  
 NUT

Location Loc Qty Loc Code

ST303 43  
 113845 5  
 114934 3  
 115594 4  
 115884 31

*Handwritten:* 11/04/05

D3536-25 Manufactured No 230 Each 24.0000 1 1  
  
 Gasket

Location Loc Qty Loc Code

FP 12  
 65903 12  
 FP12 9  
 64446 9  
 FP-12 3  
 39234 3

*Handwritten:* 11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 25, 2011 1:09:40 PM

Work Order ID: 66755

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00


Required Qty: 1.00

D3631-1      Manufactured      No      230      Each      144.0000      8      8  
  
Washer

Location      Loc Qty      Loc Code

ST072      144

63647      144

D3791-1      Manufactured      No      230      Each      14.0000      1      1  
  
Wearplate

Location      Loc Qty      Loc Code


FP017      3

39276      1

39418      2

FP17      11

62239      11


AN960C10L      NAS1149C0332      Purchased      No      230      Each      127.0000      38      38  
R  
  
washer

Location      Loc Qty      Loc Code

ST245      127

107534      59

108246      68

D2745      Manufactured      No      230      Each      121.0000      8      8  
  
Bushing

Location      Loc Qty      Loc Code

ST023      121

52311      5

59112      4

61988      4

63315      108

Friday, February 25, 2011 1:09:40 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:40 PM

Work Order ID: 66755

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,024.000

34

34



Bolt



*34 11/04/05*

Location

Loc Qty

Loc Code

ST350

1024

107862

68

108302

34

114330

11

115015

13

115371

4

115422

100

115835

194

116419

500

116549

100

*x20*

*x14*

D3537-1

Manufactured

No

230

Each

33.0000

3

3



Wearpad



*3 11/04/05*

Location

Loc Qty

Loc Code

FP017

33

37749

6

65057

27

*B65927*

*x3*

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER \*NAS1149C08332R / M114915



*(x1) 11/04/05*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:41 PM

Work Order ID: 66755

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011


Start Qty: 1.00

Required Qty: 1.00

D3492-043      Manufactured      No      230      Each      41.0000      8      8  
  
 Plug Assembly


Location	Loc Qty	Loc Code
FP	2	1366931
54682	2	
FP013	39	
59117	1	
59190	4	
63996	2	
65070	32	

*Handwritten:* 11/09/05

AN3C6A      Purchased      No      230      Each      359.0000      4      4  
  
 BOLT

Location	Loc Qty	Loc Code
ST351	359	
111982	134	
116419	75	
116549	50	
116704	100	

*Handwritten:* 11/09/05

NAS1611-013      Purchased      No      230      Each      248.0000      8      8  
  
 O-RING

Location	Loc Qty	Loc Code
FP	248	
115460	100	
115589	28	1117291
115812	20	
116582	100	

*Handwritten:* 11/09/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:41 PM

Work Order ID: 66755

Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011



Required Date: 3/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-25 Manufactured No 230 Each 21.0000 1 1  
  
 Wearshoe  
 xl 4/05/07



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	21	
38867	1	
39716	2	
<u>62233</u>	6	<u>xl</u>
65167	12	

D3794-1 Manufactured No 230 Each 15.0000 1 1  
  
 Gasket  
 xl 4/04/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP010	15	
39279	1	
39421	2	
<u>61704</u>	12	<u>xl</u>

MS21043-6 Purchased No 230 Each 546.0000 4 4  
  
 NUT  
 xl 4/04/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST301	546	
<u>112314</u>	546	<u>xl</u>

D3493-1 Manufactured No 250 Each 32.0000 2 2  
  
 Washer  
 xl 11/4/08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST062	32	
62677	32	<u>2</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 25, 2011 1:09:41 PM

Page 11

Work Order ID: 66755

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

43.0000

2

2

NUT

Location

Loc Qty

Loc Code

ST303

43

113845

5

114934

3

115594

4

115884

31

AN8C21A

Purchased

No

250

Each

71.0000

2

2

BOLT

Location

Loc Qty

Loc Code

ST345

71

113558

1

114653

2

115723

8

116381

60

D3672-1

Manufactured

No

230

Each

1,077.000

8

8

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1077

42329

10

52505

67

64177

1000



Friday, February 25, 2011 1:09:42 PM

Shop Packet Print

Page 11

W/O: 66753 Par. Chg.

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/05	230	INSTALL & ASSEMBLE WITH NAS1515H32 / K113362		11-04-05			mlw 11-04-05

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Picklist Print

Friday, February 25, 2011 1:09:42 PM

Work Order ID: 66755



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

79.0000

1

1



Blade, 350 Skidtube



11/4/148

Location

Loc Qty

Loc Code

ST466

79

60210

6

61341

33

63589

40

D3532-1

Manufactured No

250

Each

31.0000

2

2



Spacer



11/4/148

Location

Loc Qty

Loc Code

ST065

31

62218

31

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44755  
PL11-02-25

RELEASED  
08-07-16

#### GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE OSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN AG-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L, REMOVE D2741, QTY (2) AN960C816, REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2735 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	RAH	DRAWING NO.	REV. F
MFG. APPR.	RAH	D2750	SHEET 1 OF 11
APPROVED	RAH	TITLE	SCALE
DE APPR.	RAH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

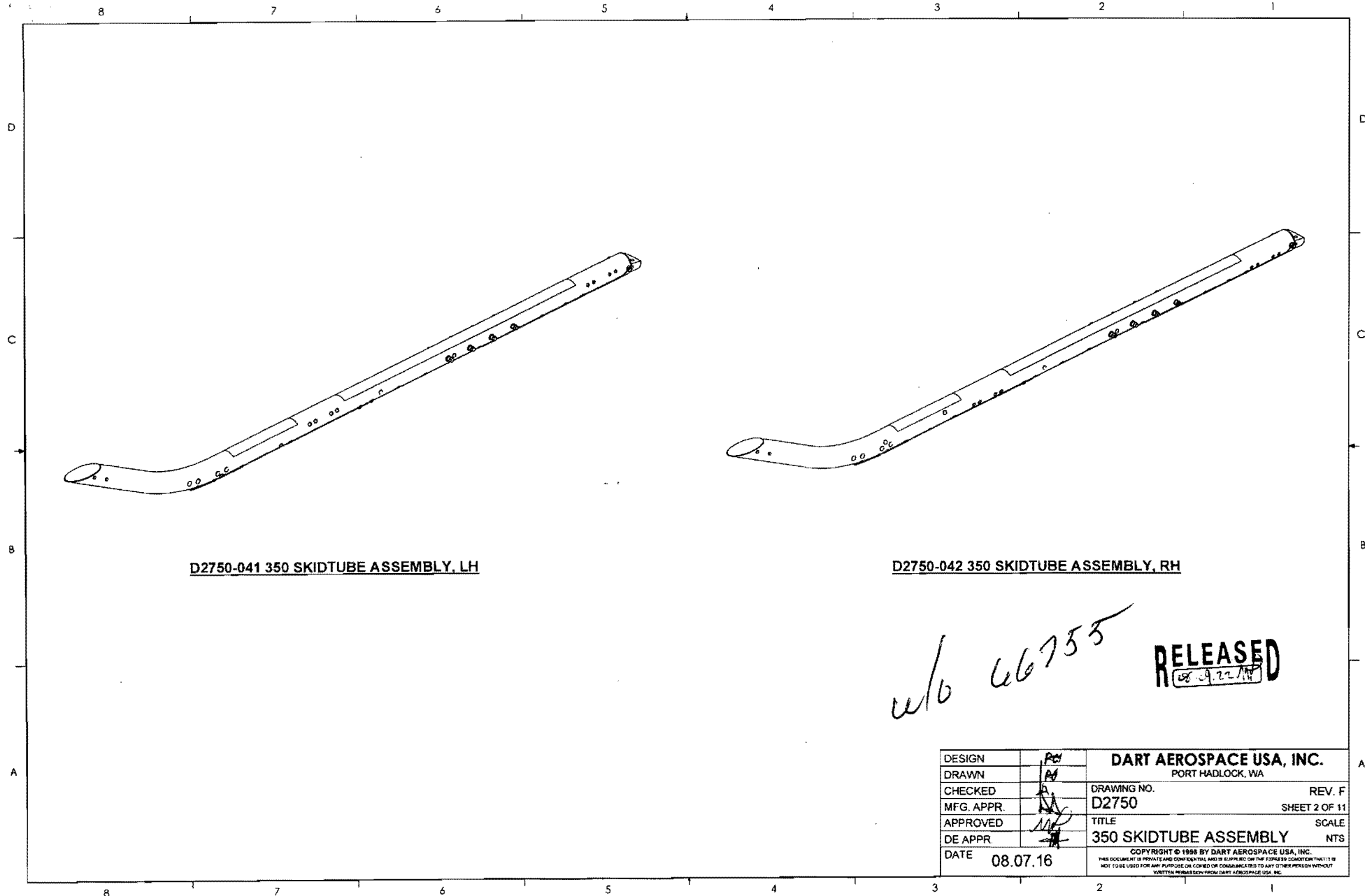
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

*w/o 66755*

**RELEASED**  
08-09-22/14

DESIGN	PCW	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	MA	SHEET 2 OF 11	
APPROVED	MA	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
DE APPR	MA	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
DATE <b>08.07.16</b>		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FOLLOWING CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

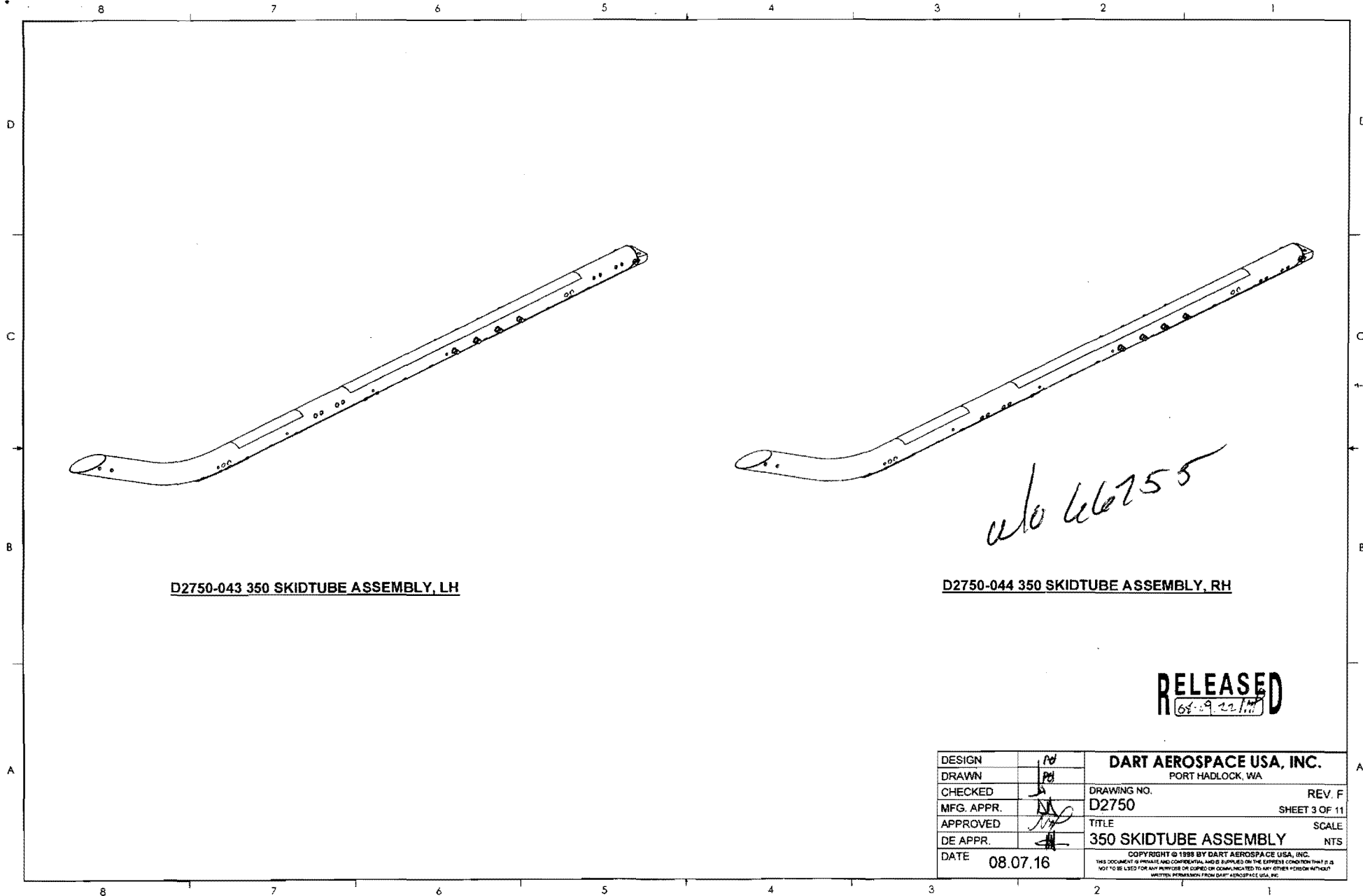
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





*u/o 46255*

**RELEASED**  
64-9-22/11

DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PH</i>	<b>D2750</b>	SHEET 3 OF 11
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

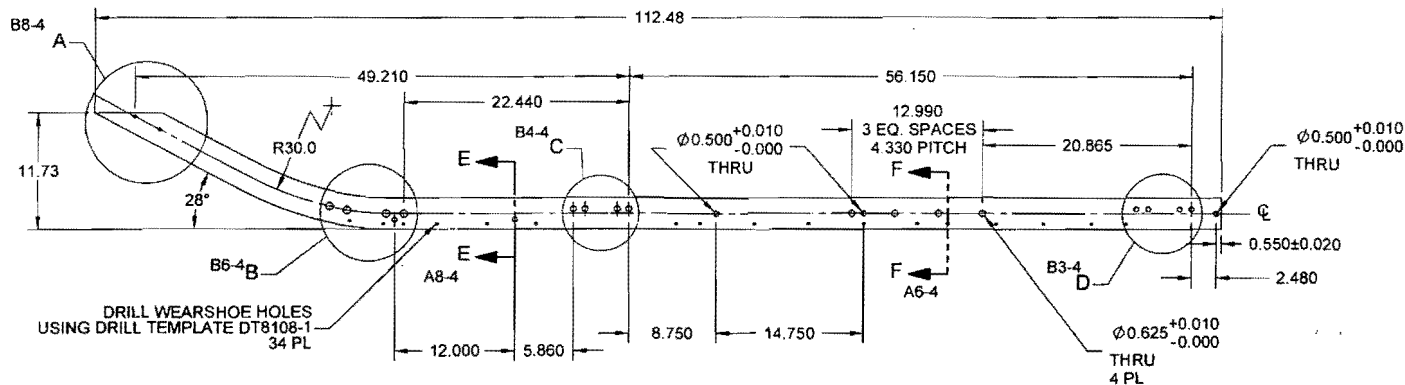
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

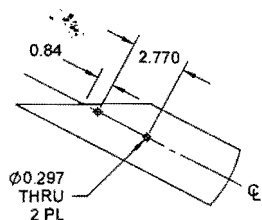
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

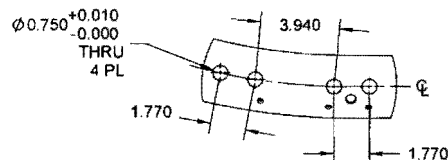
**NOTE:** Date & initial all entries



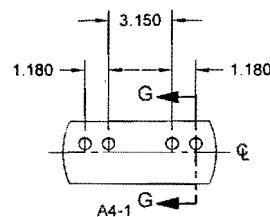
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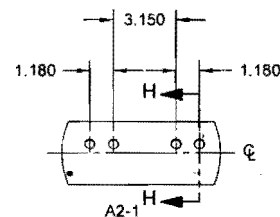
**DETAIL A**  
SCALE 2X



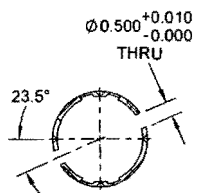
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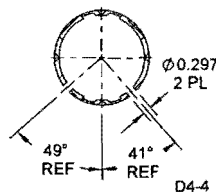
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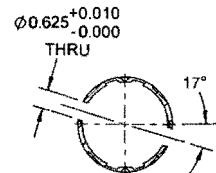
**DETAIL D**  
SCALE 2X



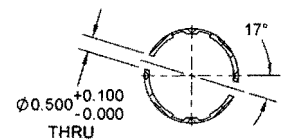
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

*u1066755*

**RELEASED**

DESIGN	IP	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	PS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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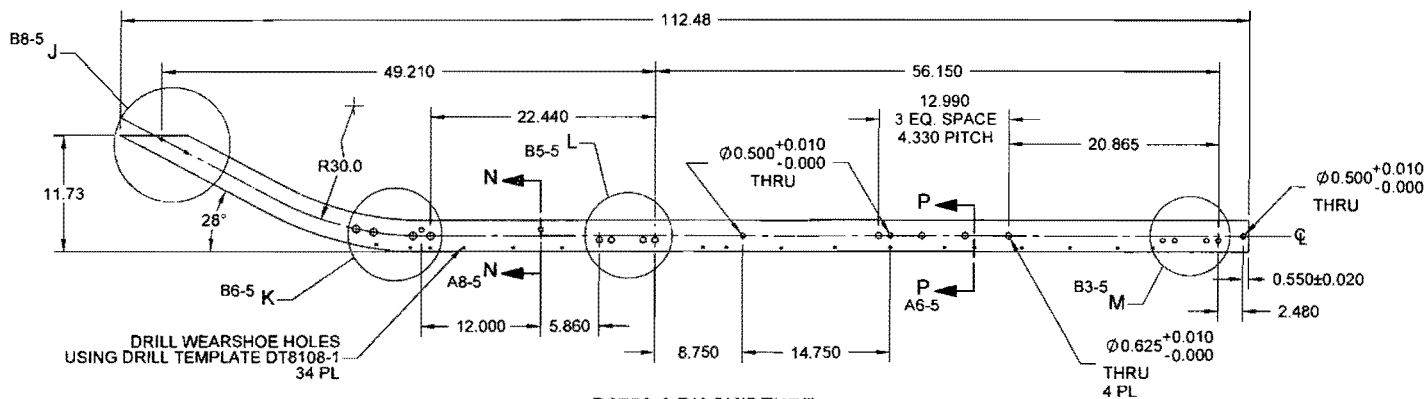
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

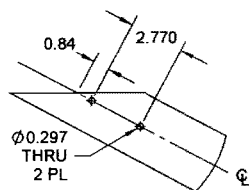
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

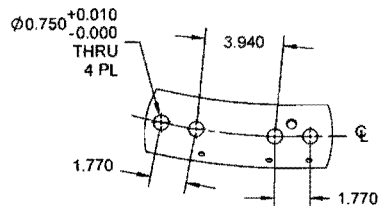
**NOTE:** Date & initial all entries



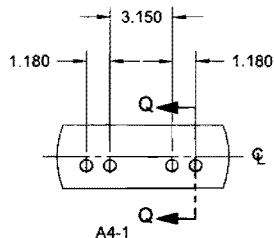
**D2750-2 RH SKIDTUBE**



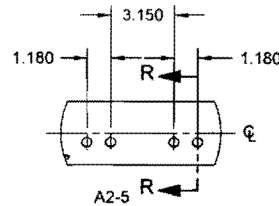
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SCALE 2X



**DETAIL K**  
SCALE 2X

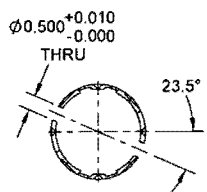


**DETAIL L**  
SCALE 2X

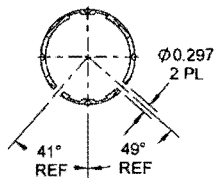


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SCALE 2X

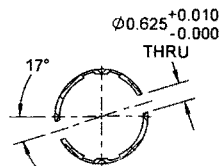
*u666755*



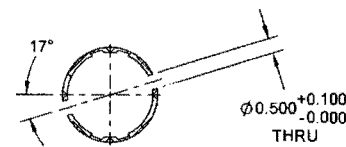
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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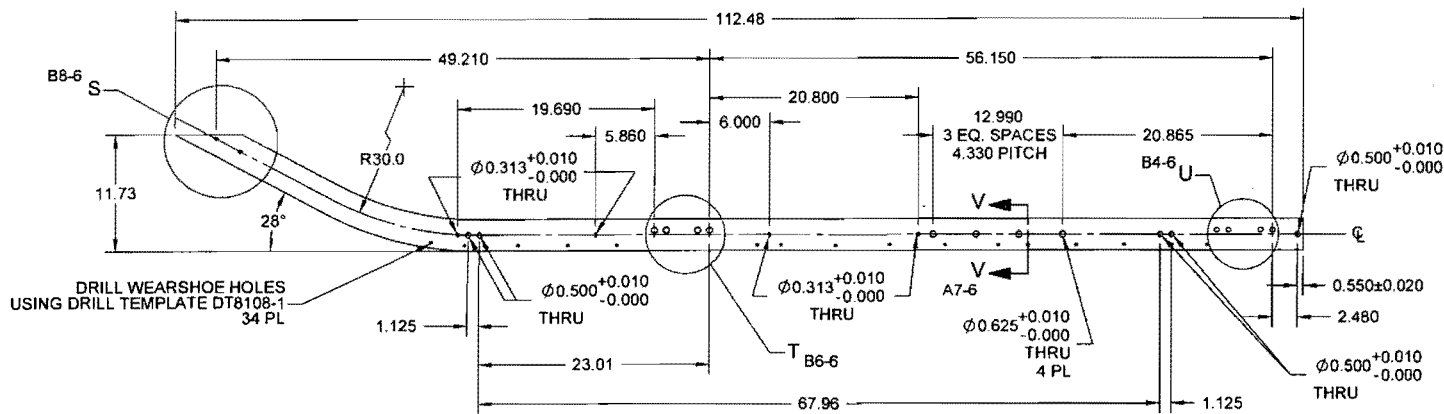
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

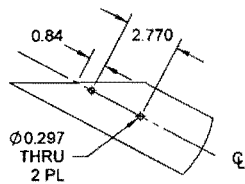
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

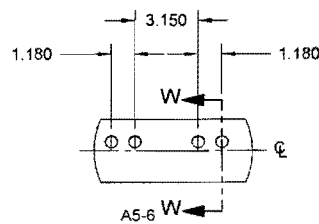
**NOTE:** Date & initial all entries



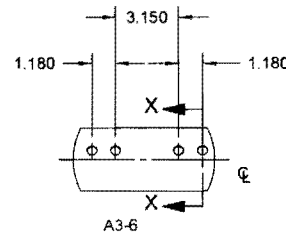
**D2750-3 LH SKIDTUBE**



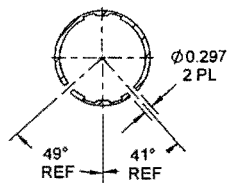
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SCALE 2X



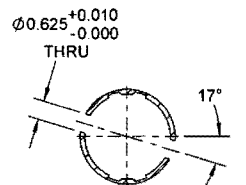
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SCALE 2X



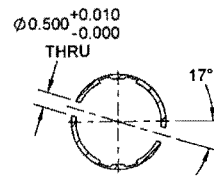
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

*w/lo 66755*

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

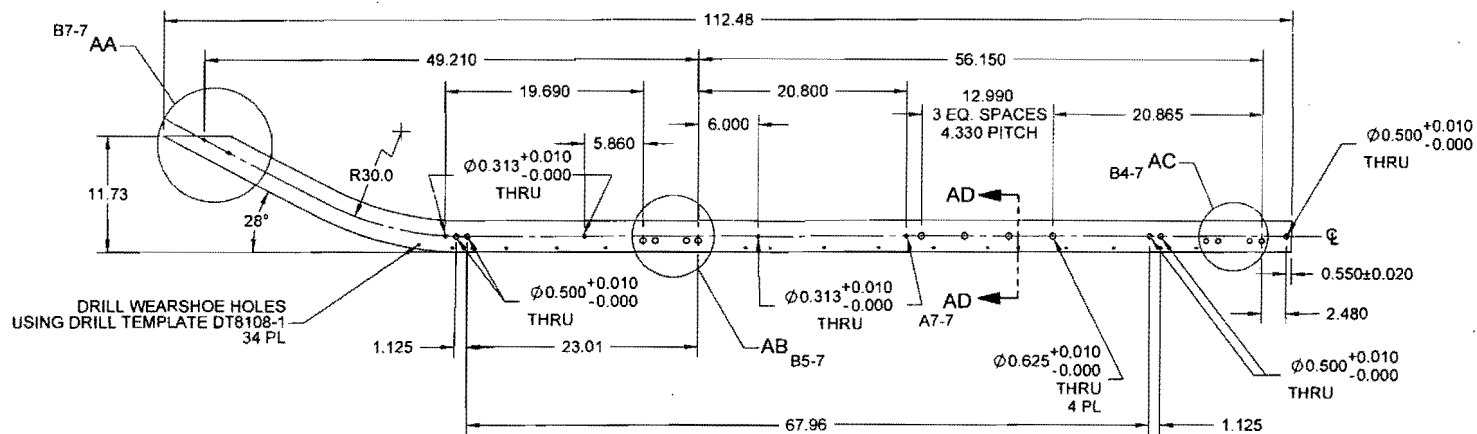
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

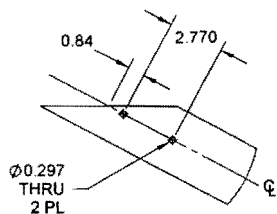
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

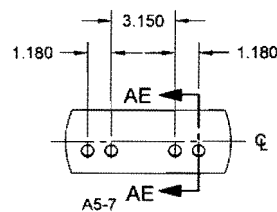




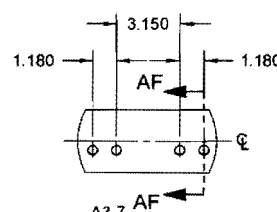
**D2750-4 RH SKIDTUBE**



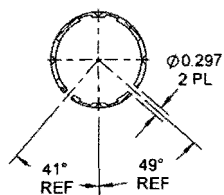
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SCALE 2X



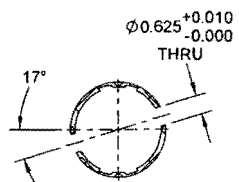
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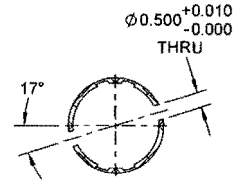
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*w/ 46753*

**RELEASED**  
08-04-2016

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>
DRAWN	PA	PORT HADLOCK, WA
CHECKED	PA	DRAWING NO. <b>D2750</b>
MFG. APPR.	PA	REV. F
APPROVED	PA	SHEET 7 OF 11
DE APPR.	PA	TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	08.07.16	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

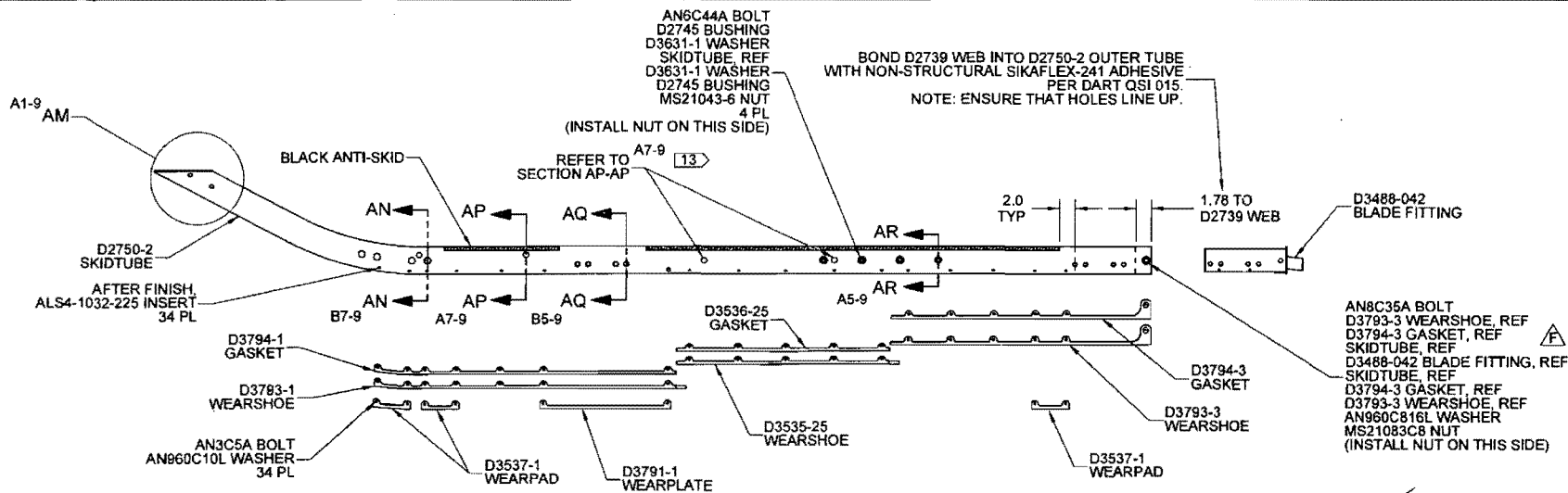
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



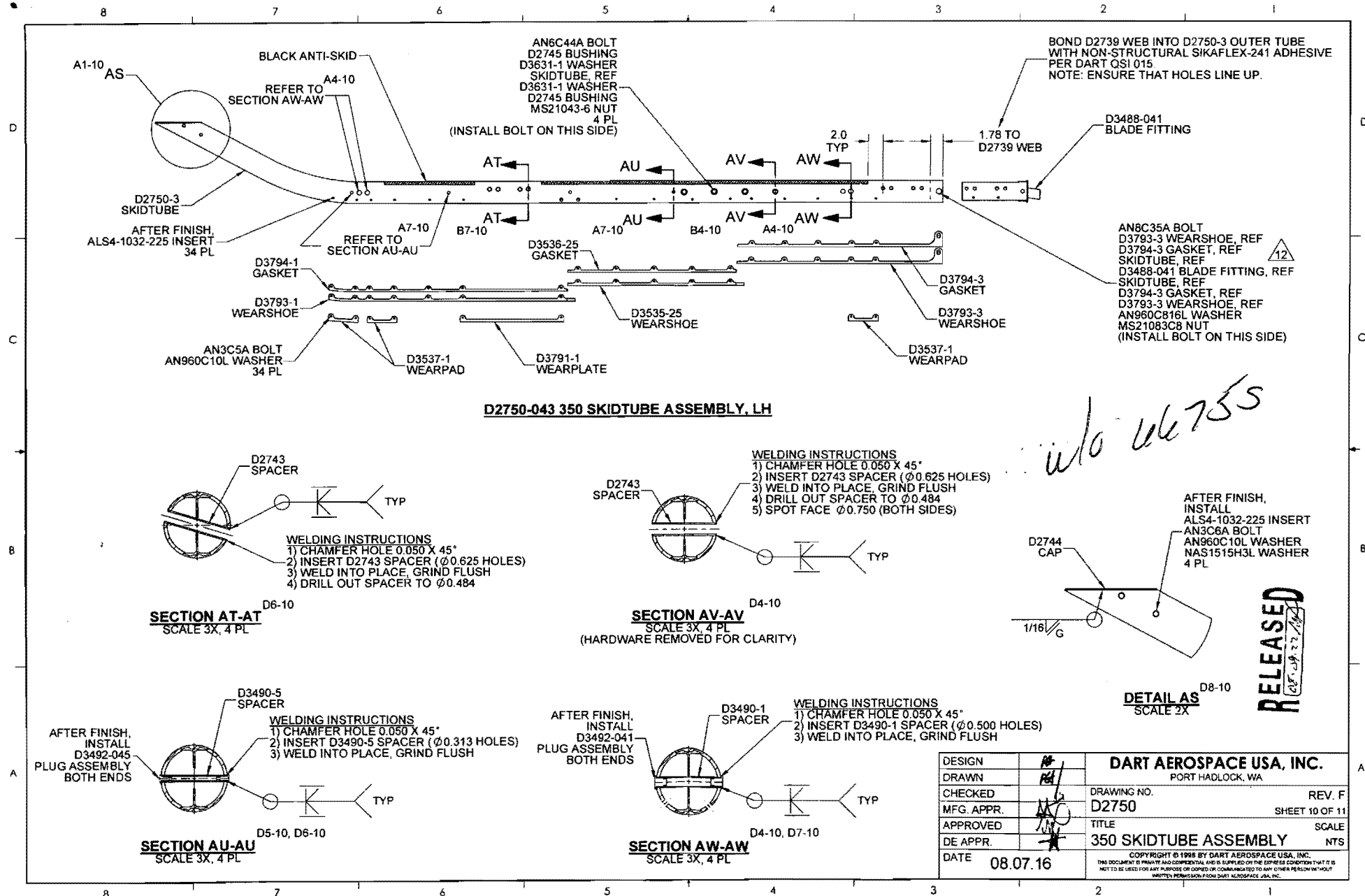
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

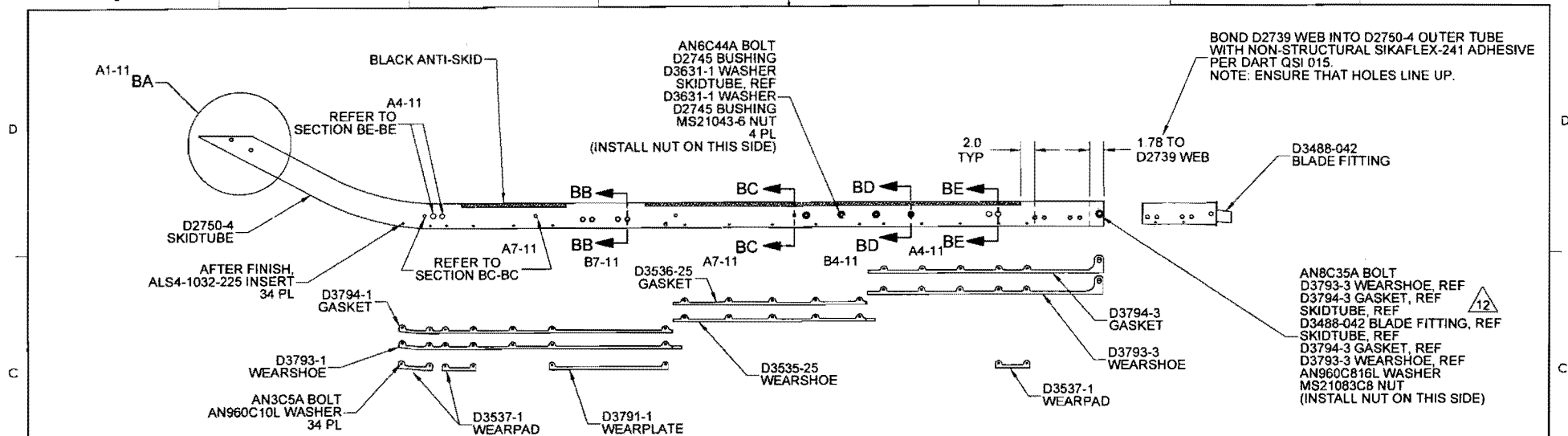
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

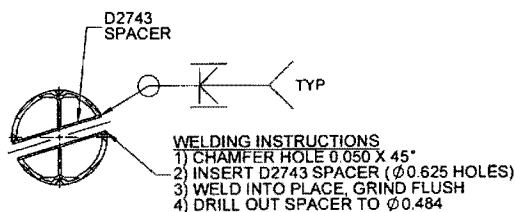
**NOTE:** Date & initial all entries



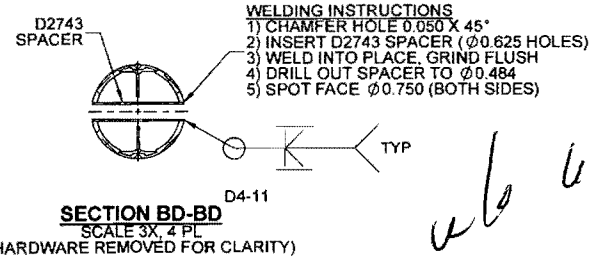
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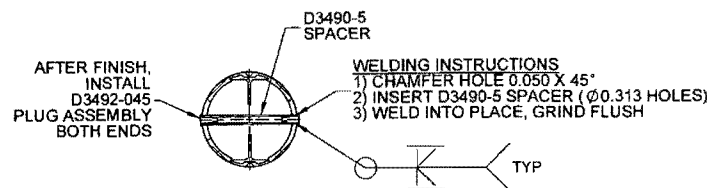
# **D2750-044 350 SKIDTUBE ASSEMBLY, RH**



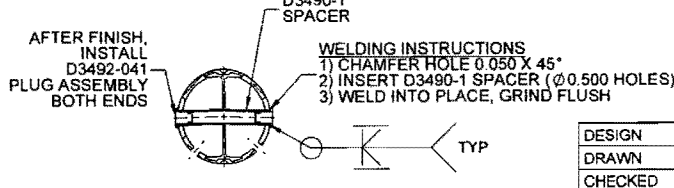
## **SECTION BB-BB** SCALE 3X, 4 PL



## **SECTION BD-BD** SCALE 3X, 4 PL

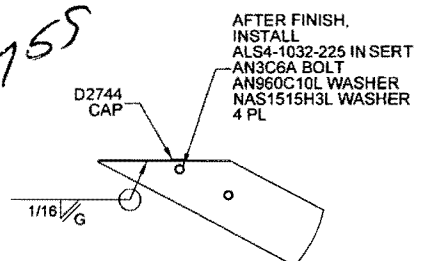


## **SECTION BC-BC** SCALE 3X, 4 PL



## **SECTION BE-BE** SCALE 3X, 4 PL

**RELEASED**  
6-10-22



## **DETAIL BA** SCALE 2X

DESIGN	HA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	<b>D2750</b>	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 243

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barkley Elliott  
Job number: ~~64950~~ 64953  
Part number: S 350-636-016  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Sal Lewis Date of Test Coupon 11-01-18

Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

